



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2498**Job Sheet 197567****Part No:** D2498**Job Qty:** 6 pcs**Part Name:** Mounting Lug**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 7/10/19**Job Tracking No:****Due Date:** 8/16/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG REV B IPP A 02.06.06 New Issue NG IPP B Rev B dwg 07-09-25 DD verified by EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	6 pcs		8/16/19	0.00	0.40	Bandsaw - 1		cancel 19/08/02
110	HAAS 4 Axis - B4B	6 pcs		8/16/19	1.00	3.00	HAAS - 1 - B4B		
							HAAS - 2 - B4B		cancel 19/08/02
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	6 pcs		8/16/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		cancel 19/08/02
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		

**Container No:** S202452**Part:** D2498**Job No:** 197567**Serial No/Batch:** S202452**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/02/19

Plex 7/10/19 12:48 PM Dart.lajeunesse.marie

				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130	QC 8	6	8/16/19	0.00 0.00	QC 8 - 12
		pcs			QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
140	Handfinish - 1-1 Chemical-B4B	6	8/16/19	0.00 0.96	Handfinish - 1 - 1 - B4B
		pcs			Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 - B4B
					Handfinish - 1 - 15 - B4B
					Handfinish - 1 - 16 - B4B
					Handfinish - 1 - 17 - B4B
					Handfinish - 1 - 18 - B4B

B-19-08-02

AUG 06 2019

				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150	Powdercoat - 2 White Gl(S)- B4B	6 pcs	8/16/19	0.00 0.80	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
160	QC 3	6 pcs	8/16/19	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
					QC 3 - 43
					QC 3 - 24
					QC 3 - 61
					QC 3 - 81
170	Packaging 3-1 - Stock - B4B	6 pcs	8/16/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B

BEB 19-08

DAS
AUG 16 2019 40
9-89

PC STS27

				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	6 pcs	8/16/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - (Bandsaw)Cut blanks: 8.500" x 4.000" ***ONE BLANK MAKES TWO PART*** Descriptions: 110 - (HAAS CNC vertical machine #1)Machine as per folio D2498 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) *****mask slot as per dwg***** START TIME: <u>3:40</u> TEMP <u>375°</u> 160 - (QC3- Inspect Part Finish) <u>5193459. FINISH: 3:55</u> 170 - (Identify as per dwg & Stock Location: _____) 180 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6B1.000X04.000	6061-T6 Bar 1.00 X 4.00	2.4000 ft (.4 ea)	100-Bandsaw - 1	<u>SIS 0595 = 2.14</u>	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Bandsaw - 1	M6061T6B1.000X04.000	2	47	0	
Part Specifications					
Specifications could not be found.					

Plex 7/10/19 12:48 PM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 197567
Description: Mount		Part Number: D2498
Inspection Dwg: D2498	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.375	+/-0.010	0.376	✓		Heig 6	31006
0.625	+/-0.010	0.626	✓		vern	mm L-05
1.419	+/-0.010	1.419	✓		"	
1.875	+/-0.010	1.876	✓		"	
2.469	+/-0.010	2.469	✓		"	
3.375	+/-0.010	3.375	✓		Heig 6	31006
0.375	+/-0.010	0.375	✓		"	
0.875	+/-0.010	0.875	✓		dept 6	
1.500	+/-0.010	1.503	✓		vern	mm L-05
3.150	+/-0.010	3.150	✓		"	
3.775	+/-0.010	3.775	✓		Heig 6	31006
4.825	+/-0.010	4.825	✓		"	
0.500	+/-0.010	0.500	✓		vern	mm L-05
5.325	+/-0.010	5.330	✓		"	
0.115	+/-0.010	0.116	✓		"	
1.000	+/-0.010	0.990	✓		microm	mm L-01
0.770	+/-0.010	0.768	✓		vern	mm L-05
0.20	+/-0.010	0.204	✓		microm	mm L-01
0.40	+/-0.010	0.400	✓		Depth 6	
0.250	+/-0.010	0.243	✓		vern	mm L-05
0.500	+/-0.010	0.503	✓		"	
R0.50	+/-0.010	0.500	✓		R 6	
R0.38	+/-0.010	0.38	✓		"	
0.25	+/-0.010	0.244	✓		vern	mm L-05
R0.25	+/-0.010	0.25	✓		R 6	
R0.25	+/-0.010	0.25	✓		"	
R0.13	+/-0.010	0.13	✓		"	
Ø0.257	+0.006/-0.001	0.258	✓		vern	mm L-05
Ø0.316	+0.006/-0.001	0.317	✓		"	

Measured by: JML	Audited by: Bn	Prototype Approval:	N/A
Date: 19/08/01	Date: 19-08-02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.11	New Issue	KJ/DD	
B	18.05.25	Dimension change was: R0.58 is: R0.38	MG	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					